

Wednesday, 11/02/2009 1:18:12 PM
Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 45748
Estimate Number : 11948
P.O. Number :
This Issue : 11/02/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : SMALL / MED FAB
Previous Run : 41527

Drawing Name : COLLECTIVE LOCK

Part Number : D3372041
Drawing Number : D3372 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 28/02/2009

Qty: 2 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev:A Removed from 9 Digit 06-01-13 JLM
Est Rev:B Added Key ID 06.03.21 EC

week 15

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D27287

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D2728-7 Decal 22554

FF 09-04-06

2.0

D33721

Main Body



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3372-1 Main Body 43258

FF 04-04-06

3.0

D33725

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3372-5 Cam Lock Shaft B22290

FF 09-04-06

4.0

D33727

Slider Body



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

Qty Part Number Description Batch
1 D3372-7 Slider Body B22291X1
B43259X7

FF 09-04-06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D33731

Cam Lock



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description

1 D3373-1 Cam Lock

Keys alike

B 44105

keys dislike

B _____

CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE

FF 07-04-06

6.0

AN542A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt B108034

FF 07-04-06

7.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC SS Flat Washer 110138

A/RN/A Locktite 262 109905

FF 07-04-06

8.0

D33841

Cyclic Sock



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1 Cyclic Sock B45752

FF 07-04-06

9.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460 Loop Sleeve 1109062

FF 07-04-06

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

CBL1240

Cable



Comment: Qty.: 0.6999 f(s)/Unit Total: 5.5994 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable M107234

FF 09-04-06

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer 19356

FF 09-04-06

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M110383

FF 09-04-06

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

FF 09-04-06

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0 09/04/06

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

FF 09/09/06

Wednesday, 11/02/2009 1:18:12 PM
Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262 109905

Identify as D3372-053

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

FF 09-04-08

(2)

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/R N/A SS Rod

WCE715

SP 09-04-07

8X

18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09-04-08

x2

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S09/04/08

(2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: #10 PPP.46926

S09/04/08 x2

Record Keys alike #

Record Keys dislike #

C420A
C420A

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 45748

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

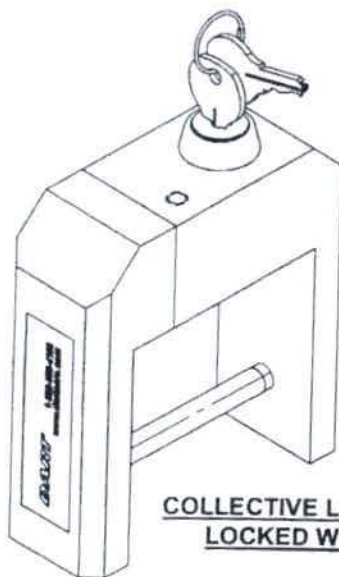
D 09/04/08

Job Completion

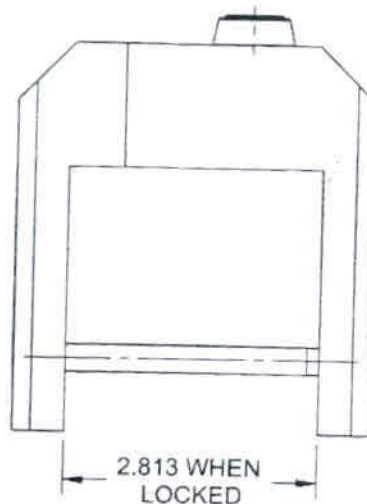
MF
09-04-08

DART

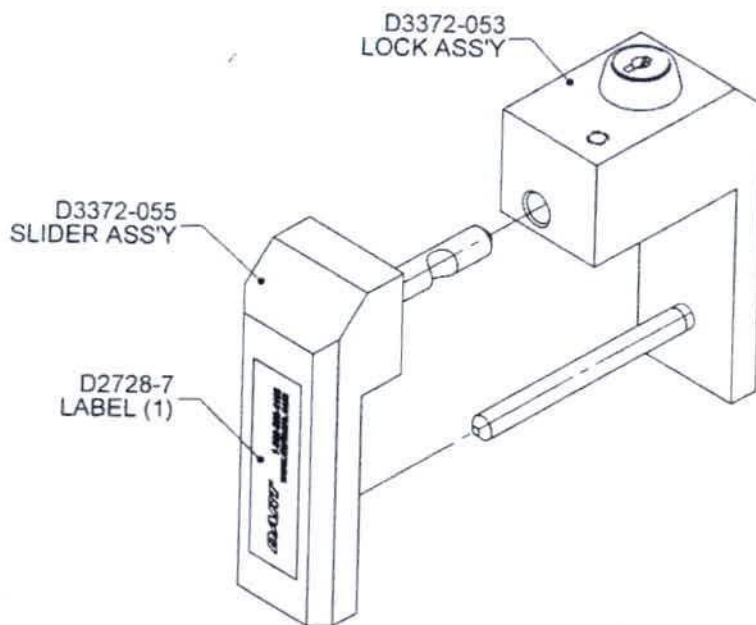
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE	05.02.23	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



2.813 WHEN
LOCKED



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

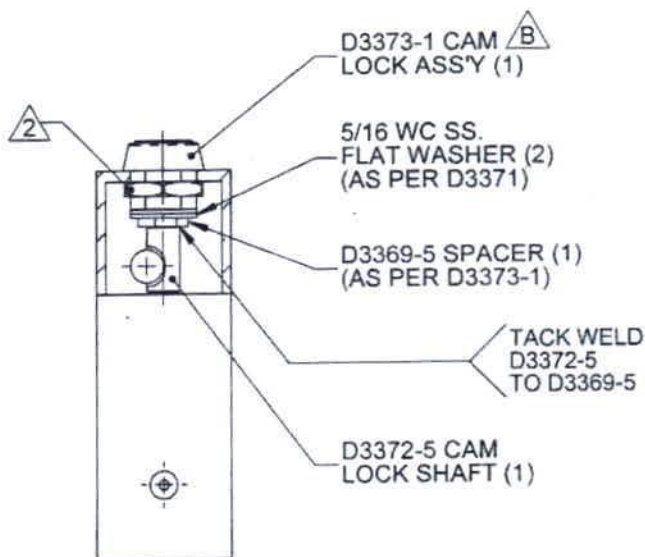
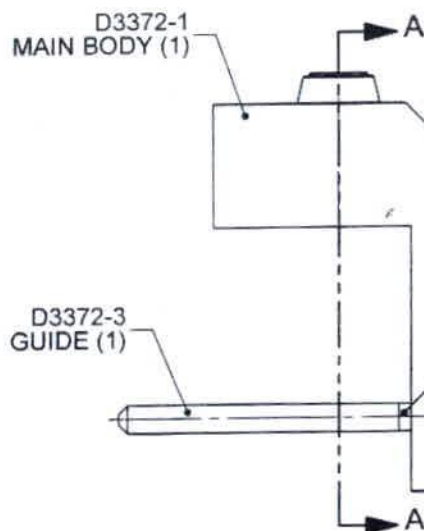
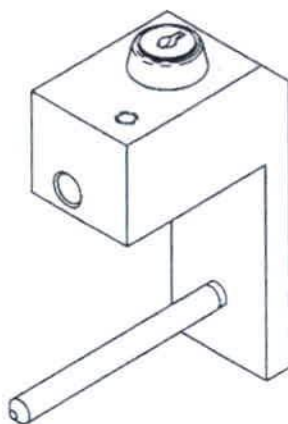
RELEASED
05/04/28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. N5148

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

RELEASED
[Signature]
2/6/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

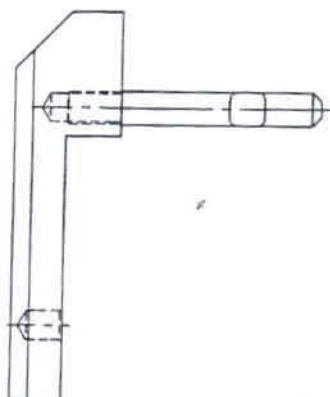
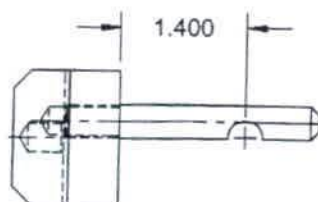
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45148

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

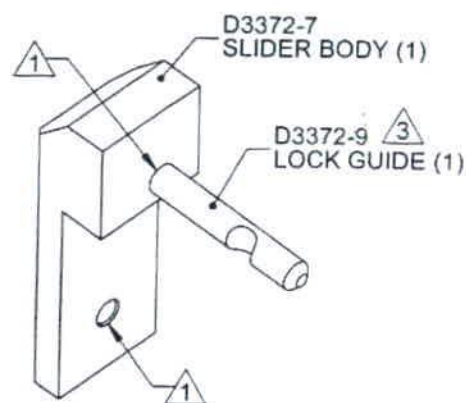
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

**RELEASED**

05/04/23

**D3372-055 SLIDER ASS'Y****NOTES:**

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45148

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

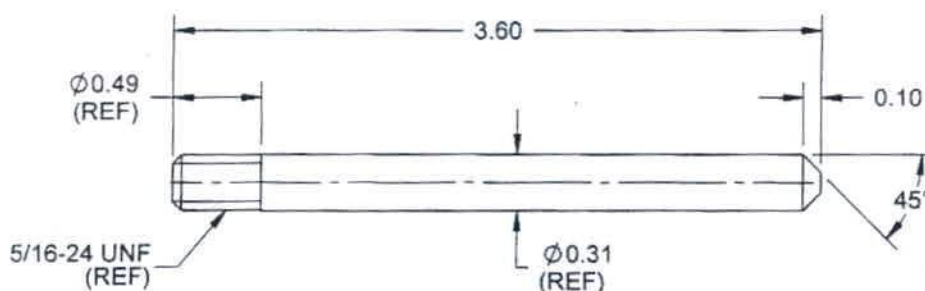
DART

DESIGN <i>43</i>	DRAWN BY <i>43</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TF</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:1

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]

05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *45148*

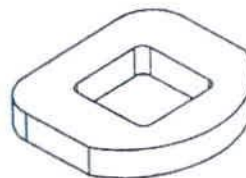
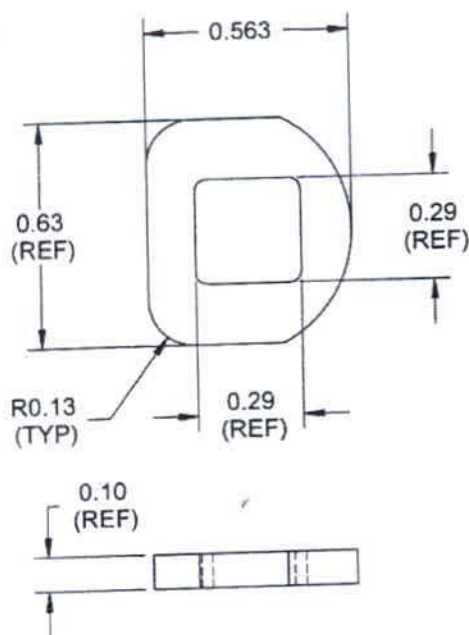
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]
08/01/17

- 5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45748*

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

3

2

1

D

C

B

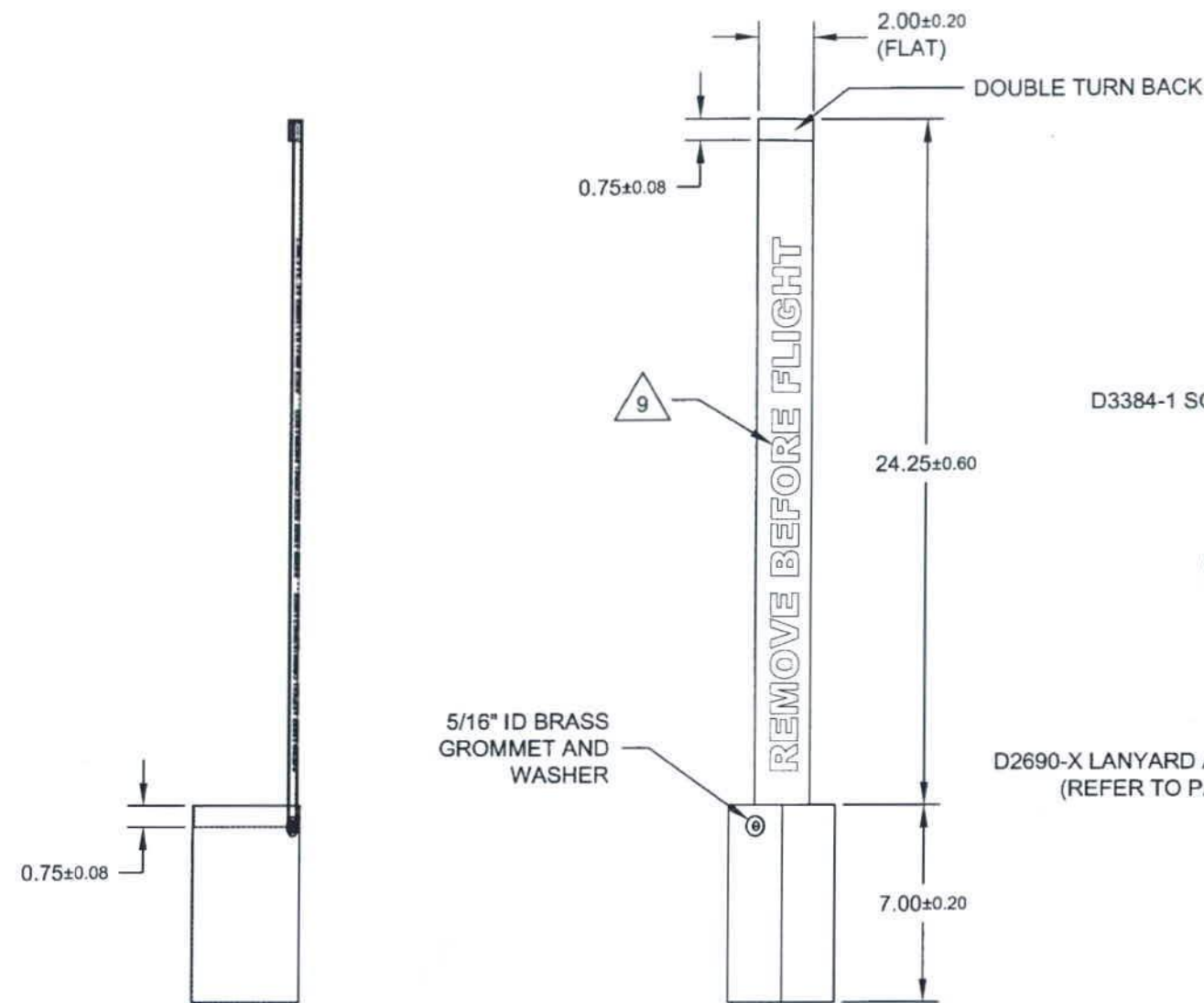
A

D

C

B

A

**D3384-1 SOCK**

D3384-1 SOCK

D2690-X LANYARD ASSEMBLY
(REFER TO PARTS LIST)**D3384-0XX SOCK ASSEMBLY**

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
	1				D2690-8	LANYARD ASSEMBLY
		1			D2690-20	LANYARD ASSEMBLY
1					D2690-24	LANYARD ASSEMBLY
			1		D2690-28	LANYARD ASSEMBLY
				1	D2690-30	LANYARD ASSEMBLY
1	1	1	1	1	D3384-1	SOCK

D3384-1 NOTES:

- 1) SUPPLIER: TULMAR P/N 8972
MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
- 2) THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD, TY2, CL A, SIZE E
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING INK, WHITE, IAW A-A-208

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 45748

RELEASED
07.11.23

B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	CP	D3384	SHEET 1 OF 1
APPROVED	MD	TITLE	SCALE
DE APPR.	N/A	SOCK ASSEMBLY	NTS
DATE	07.11.23	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

